

Ship 6 Rev.

Work Order ID 156122

156122

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Thursday, January 26, 2017 11:16:32 AM

Item ID: D4820-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: FPC Clip Assembly
 Start Date: 2/2/2017 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 2/6/2017 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan:  Date: JAN 26 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4820	A

100	Pick Kit	0.00							
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100

Packaging Memo 0.00

Packaging

40x 12/02/02 DAS 36 9-89

110		0.00							
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110

Small Fab Memo 0.13

Small Fab Assemble as per dwg and grind rivet flush as shown

40x 12/02/02 DAS 36 9-89

120	QC5- Inspect part completeness to step on W/O	0.00							
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120

QC Memo 0.13

Quality Control

40 38 2-80
FEB 02 2017

Work Order ID 156122***156122***

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St129</u>	0.00					<u>40</u>	<u>DAS 21 9-89</u>	<u>FEB 03 2017</u>
130									
Packaging	Memo	0.07							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00					<u>DAS 21 9-89</u>	<u>FEB 03 2017</u>	
140									
QC	Memo	0.67							
Quality Control							<u>DAS 21 9-89</u>	<u>FEB 03 2017</u>	

Picklist Print

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Work Order ID: 156122

156122

Parent Item: D4820-041

D4820-041

Parent Item Name: FPC Clip Assembly

Start Date: 2/2/2017

Required Date: 2/6/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 13-04-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4820-1		Manufactured	No				Each	0.0000		40			
D4820-1									**	40		17/02/02	DAS 36 9-89
Fpc Clip Base													
D4820-3		Manufactured	No				Each	3.0000		40			
D4820-3									**	40		17/02/02	DAS 36 9-89
Fpc Clip Profile													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		3							
					142279	3							
MS20426AD4-4		Purchased	No				Each	3,494.000		40			
MS20426AD4-4									**			17/02/02	DAS 36 9-89
Rivet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1553							
					125445	1553				40			
				ST312		1941							
					m132536	1941							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

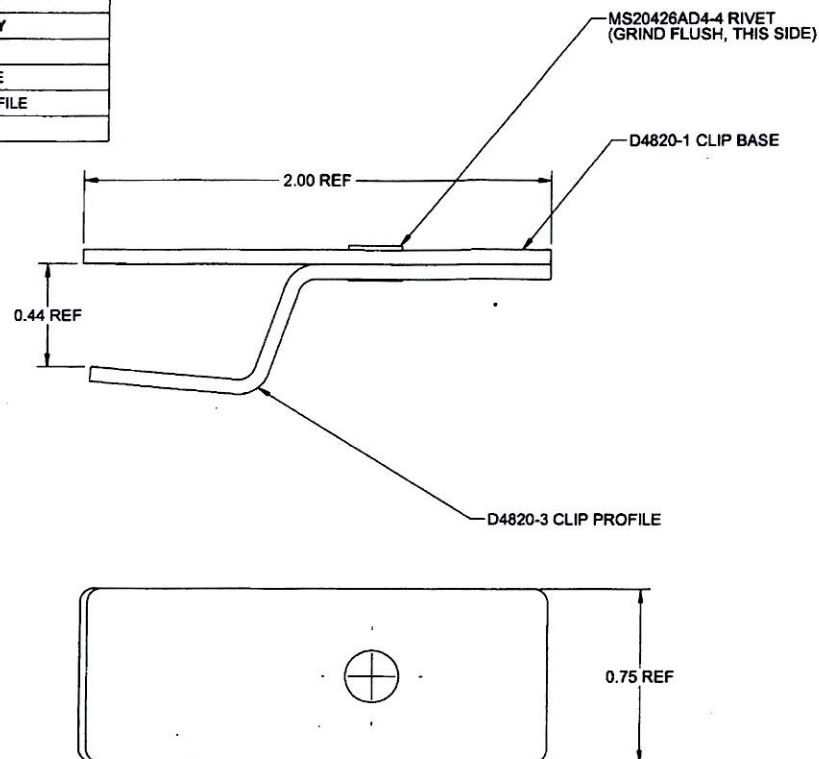
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

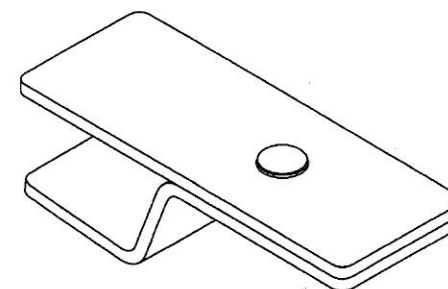
ITEM	QTY 041	P/N	DESCRIPTION
	X	D4820-041	CLIP ASSY
1	1	D4820-1	CLIP BASE
2	1	D4820-3	CLIP PROFILE
3	1	MS20426AD4-4	RIVET



D4820-041 CLIP ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *150122*

JAN 26 2017

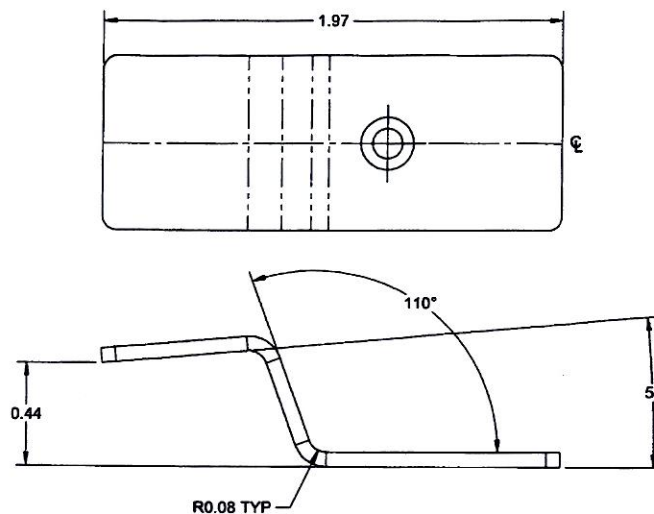


RELEASED
2013-04-18
mf

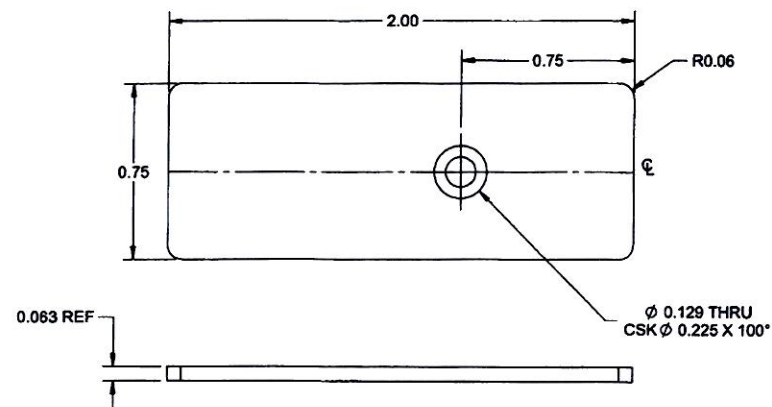
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4820-041" USING FINE POINT PERMANENT MARKER, QSI 044, METHOD 6.1
- 7) WEIGHT: 0.06 lbs

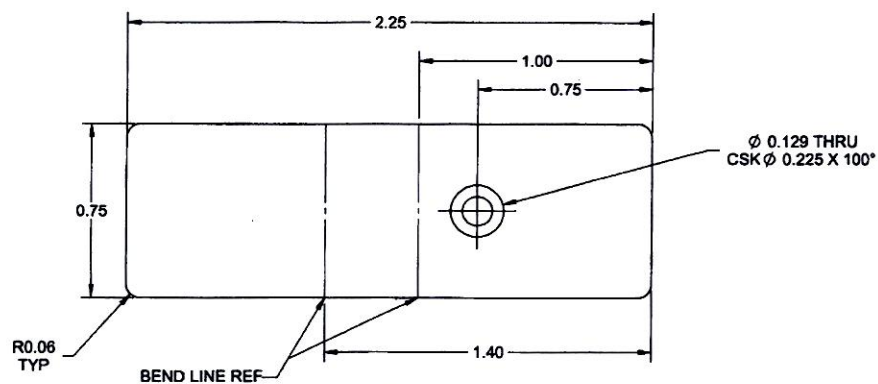
A	NEW ISSUE	DB	13.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>AP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AP</i>	D4820	SHEET 1 OF 2
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	CLIP ASSY	NTS
DATE	13.04.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4820-3 CLIP PROFILE
(MAKE FROM D4820-3F)



D4820-1 CLIP BASE



D4820-3F FLAT PATTERN

RELEASED
2013-04-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 0.063" THICK AS PER DART SPEC M304S18GA1P OR MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4820-1: 0.03 lbs, D4820-3: 0.03lbs

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4820	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSY	NTS
DATE	13.04.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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